

**Work Order ID 63500**

Wednesday, November 03, 2010 10:39:09 A

Page 2

Item ID: D2572

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd In 205

Start Date: 11/3/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**Work Order ID 63500**

Wednesday, November 03, 2010 10:39:09 A

Page 1

Item ID: D2572

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd In 205

Start Date: 11/3/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-03 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

**Memo**

Program Batch No. 63500

Double check by: *gml*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

0.00

H.A. 10/12/01

12

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Conventional Milling Machine

**Memo**

Machine keyway as per dwg D2571 &amp; D2572

0.00

H.A. 10/12/01

12

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>10/12/15</del>	<del>148</del>	<del>mild corrosion on part where part was bolted down for machining.</del>		<del>Remove corrosion using red scotch bright pad tightly scuffing areas.</del>				

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE


NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63500**

Wednesday, November 03, 2010 10:39:09 A

Page 4

Item ID: D2572

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd In 205

Start Date: 11/3/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/10 [Signature]

ME  
10-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, November 03, 2010 10:39:13 AM

Page 1

Work Order ID: 63500



Parent Item: D2572



Parent Item Name: Saddle, Fwd In 205


Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated  
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			100	Each	41.0000	1	12			

Location

Loc Qty

Loc Code

MAT46

41

46411

1

62394

40

12.0

B.A 10/12/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	43500
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.38	0.443		0.440	0.440	0.440	0.440	Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.930	8.010		8.000	8.000	8.000	8.000	Vern	CNC-02
F	0.490	0.510		0.500	0.497	0.499	0.500	Vern	GA-01
G	0.257	0.262		0.260	0.260	0.260	0.260	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		0.499	0.500	0.499	0.500	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.568	0.568	0.568	0.569	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	3.869	3.879		3.874	3.874	3.874	3.874	"	"
P	0.115	0.135		0.125	0.126	0.126	0.126	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		0.250	0.251	0.251	0.251	"	"
S	0.115	0.135		0.128	0.125	0.126	0.126	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	2.940	2.980		2.959	2.959	2.959	2.959	Vern	GA-01
V	0.230	0.250		0.240	0.240	0.241	0.240	"	"
W	0.115	0.135		0.133	0.134	0.132	0.132	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.309	Vern	GA-01
Y	0.730	0.765		0.761	0.761	0.761	0.761	"	"
Z	0.352	0.372		0.366	0.364	0.364	0.362	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		0.625	0.625	0.624	0.623	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		0.250	0.250	0.250	0.250	Vern	GA-01
AE	1.375	1.395		1.3871	1.3885	1.388	1.388	Dial	HAAS 3
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		0.250	0.250	0.250	0.250	"	"
AH	0.240	0.260		0.250	0.248	0.247	0.250	"	"
AI	2.000	2.020		2.0037	2.004	2.003	2.0025	Dial	HAAS 3
AJ	0.023	0.043		0.033	0.033	0.033	0.033	R-6	ref.
Accept/Reject									

Measured by:	HA
Date:	10/12/01

Audited by:	DL
Date:	10/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 63500
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page</b> 2 <b>of</b> 3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8	By	Date
A	0.38	0.443		0.440	0.440	0.440	0.440	Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	CNC-02
F	0.490	0.510		0.500	0.498	0.500	0.497	Vern	GA-01
G	0.257	0.262		0.260	0.260	0.260	0.260	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		0.500	0.501	0.500	0.500	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.567	0.569	0.569	0.570	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	3.869	3.879		3.874	3.874	3.874	3.874	"	"
P	0.115	0.135		0.126	0.126	0.126	0.126	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		0.251	0.251	0.251	0.251	"	"
S	0.115	0.135		0.127	0.127	0.126	0.127	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	2.940	2.980		2.959	2.959	2.959	2.959	Vern	GA-01
V	0.230	0.250		0.240	0.240	0.240	0.240	"	"
W	0.115	0.135		0.132	0.133	0.132	0.132	Mic	118-120
X	0.307	0.312		0.309	0.311	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.761	0.761	0.761	0.761	"	"
Z	0.352	0.372		0.364	0.363	0.366	0.364	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		0.624	0.625	0.625	0.625	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		0.250	0.250	0.250	0.250	Vern	GA-01
AE	1.375	1.395		1.388	1.3885	1.388	1.3875	Dial	HAAS3
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		0.250	0.250	0.250	0.250	"	"
AH	0.240	0.260		0.250	0.250	0.250	0.250	"	"
AI	2.000	2.020		2.003	2.004	2.003	2.003	Dial	HAAS3
AJ	0.023	0.043		0.033	0.033	0.033	0.033	R-6	ref.
Accept/Reject									

Measured by:	H.A.
Date:	10/12/06

Audited by:	SL
Date:	10/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	43500
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page</b> 3 <b>of</b> 3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.38	0.443		0.440	0.440	0.440	0.440	Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.930	8.010		8.000	8.000	8.000	8.000	Vern	CNC-02
F	0.490	0.510		0.504	0.495	0.503	0.499	Vern	GA-01
G	0.257	0.262		0.260	0.260	0.260	0.260	"	"
H	0.375	0.380		0.377	0.377	0.377	0.377	"	"
I	0.490	0.510		0.501	0.501	0.501	0.501	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.570	0.569	0.569	0.570	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	3.869	3.879		3.874	3.874	3.874	3.874	"	"
P	0.115	0.135		0.126	0.126	0.126	0.126	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		0.252	0.252	0.251	0.252	"	"
S	0.115	0.135		0.125	0.126	0.126	0.127	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	2.940	2.980		2.959	2.959	2.959	2.959	Vern	GA-01
V	0.230	0.250		0.240	0.240	0.240	0.240	"	"
W	0.115	0.135		0.134	0.133	0.134	0.134	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.730	0.765		0.761	0.761	0.761	0.761	"	"
Z	0.352	0.372		0.364	0.364	0.363	0.362	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		0.625	0.625	0.625	0.625	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		0.250	0.250	0.250	0.250	Vern	GA-01
AE	1.375	1.395		1.388	1.388	1.388	1.388	Dial	HAAS 3
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		0.250	0.250	0.250	0.250	"	"
AH	0.240	0.260		0.250	0.250	0.250	0.250	"	"
AI	2.000	2.020		2.003	2.003	2.003	2.003	Dial	HAAS 3
AJ	0.023	0.043		0.033	0.033	0.033	0.033	R-6	ref.
Accept/Reject									

Measured by:	H. A
Date:	10/12/07

Audited by:	SL
Date:	10/12/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



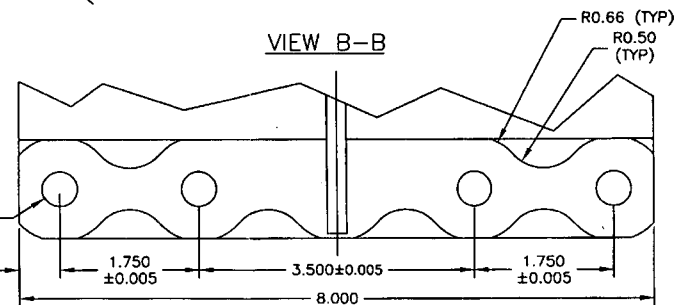
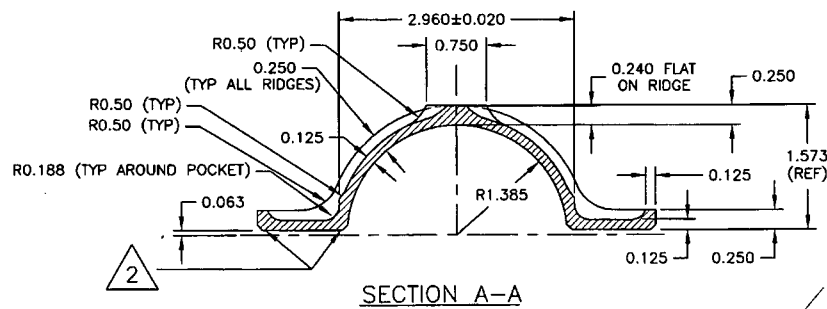
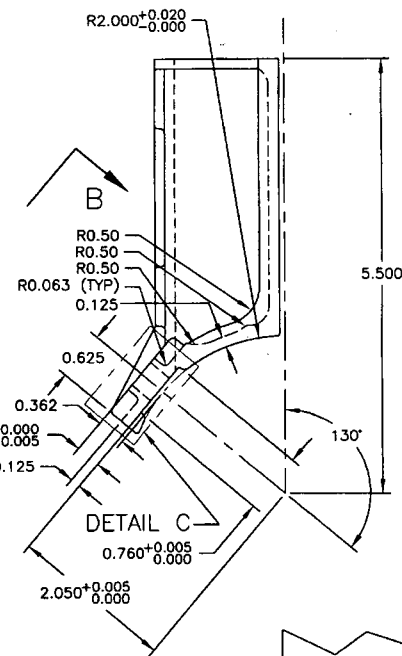
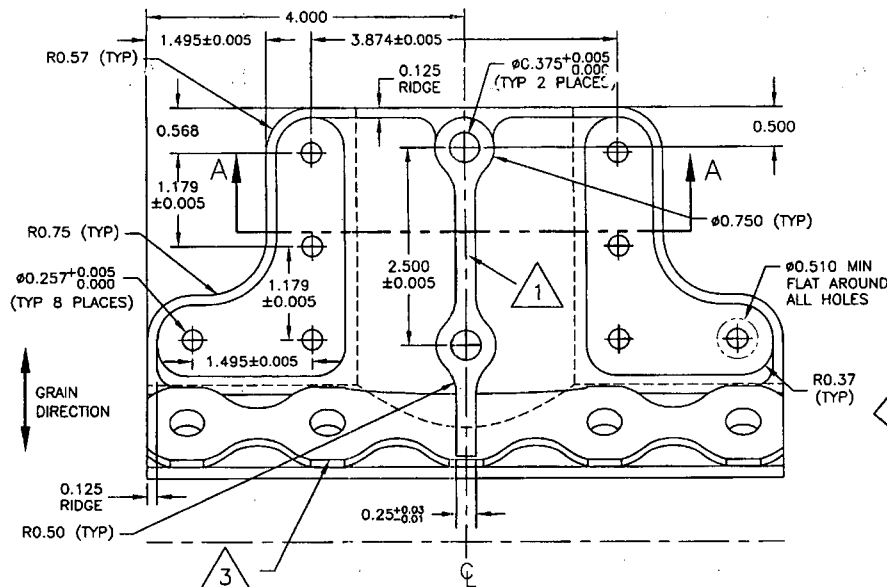
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER 05.12.06  
NO. 63500

# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C  
SCALE 2:1

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AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		INNER FWD SADDLE
		DART AEROSPACE LTD. HARVEYSBURY, ONTARIO, CANADA
		DRAWING NO. D2572
		REV. E SHEET 1 OF 1 SCALE 2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries